

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018137**Date Inspected:** 12-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	William Sherwood and John Pagliaro			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Orthotropic Box Girder		

**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 7E/8E side plate 'C' (9755mm to 10555mm) inside, ABF welders Songtao, Huang was observed 3G SMAW welding fill to cover pass on the splice butt joint. This location was manually welded using the SMAW due to limited access when using the automatic FCAW-G track mounted Bug-o nozzle holder. The welder was using 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040A. During welding, ABF QC William Sherwood was noted monitoring the welder's welding parameters. At the end of the shift, cover pass welding on location mentioned above was completed.

At OBG 8E/9E bottom plate 'D' inside, QA randomly observed ABF/JV qualified welders Xiao Jian Wan and Hua Qiang Huang perform Shielded Metal Arc Welding (SMAW) welding fill pass to cover pass on splice butt joint. The joint being welded has a single V-groove butt joint with backing bar. ABF welder Xiao Jian Wan was noted welding on the north side (600mm long) while the other welder was welding on the south side (1600mm long). The welders were using SMAW on these two locations due to limited access of the SAW track mounted feeder. Cover pass welding was completed on the north end but the fill pass welding on the south end was still continuing. During the shift, ABF QC William Sherwood was noted monitoring the welders.

The following lifting lug access holes infill plate welding was also observed;

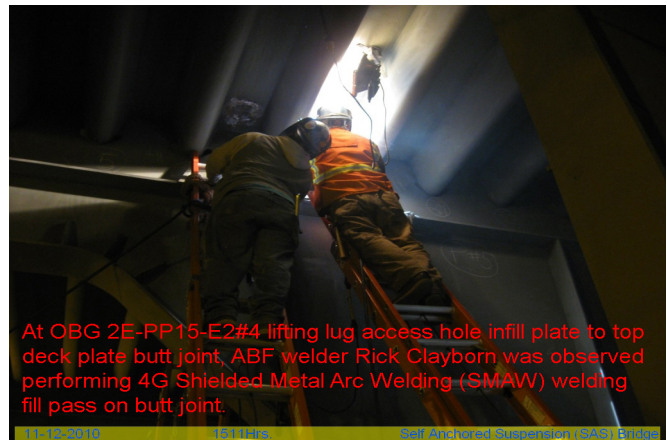
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1. At OBG 3E-PP20-E2#3 top deck plate outside – ABF welder Earl Espinosa was observed 1G SMAW welding fill to cover pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8” diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1070. During welding, ABF QC Pat Swain was noted monitoring the welder’s welding parameters. At the end of the shift, cover pass welding on this location was completed.

2. At OBG 3E-PP22-E2#4 top deck plate inside - ABF welder Darcel Jackson was observed 4G SMAW back welding cover pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8” diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. During welding, ABF QC John Pagliero was noted monitoring the welder’s welding parameters. During the shift, cover pass welding on this location was completed and the welder has moved to access hole #2 of the same location which was also completed except the grinding/cleaning of the gouged groove of the joint.

3. At OBG 2E-PP15-E2#4 top deck plate inside - ABF welder Rick Clayborn was observed 4G SMAW back welding fill pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8” diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A. During welding, ABF QC John Pagliero was noted monitoring the welder’s welding parameters. During the shift, fill pass welding on this location was still continuing which should remain Monday.



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### Summary of Conversations:

No significant conversation occurred today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo, Joselito
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill
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QA Reviewer
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